



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D5336-043
Job Sheet 180715



Part No: D5336-043

Job Qty: 1 ea

Part Name: Basket Lid Assembly, LH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/12/18

Job Tracking No:

Due Date: 7/31/18

Created By: Marie Lajeunesse

Type: SOLD *stlu*

Description:

Note: DWG REV B SHEETS 4,6,7,8 IPP REV:A 15.10.15 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		7/31/18	0.00	0.00	Start Up Large Fab-6		<i>De 2018-08-16</i>
100	Large Fab	1 pcs		7/31/18	0.00	6.59	Large Fab 1		<i>CC</i>
110	QC	1 pcs		7/31/18	0.00	0.00	QC9		<i>D 18-08-30</i>
120	QC	1 pcs		7/31/18	0.00	0.00	QC5		<i>D 18-08-30</i>
130	Powdercoat	1 pcs		7/31/18	0.00	0.13	Powdercoat4		<i>BK 18-9-11</i>
140	HandFinish	1 pcs		7/31/18	0.00	0.90	HandFinish3		<i>W 18-09-05</i>
150	QC	1 pcs		7/31/18	0.00	0.00	QC3		<i>AK 18-9-5</i>
160	Packaging	1 pcs		7/31/18	0.00	0.00	Packaging3-2		<i>En 18-09-05</i>
170	QC21-SA	1 Ea		7/31/18	0.00	0.00	QC21		<i>En 18-09-05</i>

Part Op 100 - 1- Assemble ribs , weld as per dwg D5336 using DT10196 2- Weld hinge (2) and locking brackets as per dwg
Descriptions: D5336 ***inspect before welding mesh*** 3- Cut mesh as per dwg D5334-3 4- Tack weld mesh on basket as per dwg
D5336 ***Make sure to place mesh correctly on lid, check with label plate before tacking mesh***

130 - *** Mask holes and sides of hinge prior to powdercoat*** Start Time: *2:05* . Oven Temperature: *320°*

Finish Time: *3:05*

140 - 1- Mask data plate and apply wing walk on outside surface of mesh as per dwg

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D4016-3	Hinge Half, Lid	2 Ea (2 ea)	90-Start up Operation	<i>5083907</i>
D5332-043	Rib Assembly	1 Ea (1 ea)	90-Start up Operation	<i>1163094</i>
D5332-11	Rib	1 Ea (1 ea)	90-Start up Operation	<i>5064924</i>
D5332-15	Rib	1 Ea (1 ea)	90-Start up Operation	<i>5090600</i>
D5332-17	Rib	2 Ea (2 ea)	90-Start up Operation	<i>5089147</i>
D5332-7	Rib	1 Ea (1 ea)	90-Start up Operation	<i>5064924</i>
D5332-9	Rib	1 Ea (1 ea)	90-Start up Operation	<i>5065007</i>
D5333-1	Locking Bracket	1 Ea (1 ea)	90-Start up Operation	<i>159811</i>
M304EX0.75-16F	Expanded Metal Flat SS	4.8000 sf (4.8 ea)	90-Start up Operation	<i>20205444</i>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D4016-3	2	37	0
	D5332-043	1	7	0
	D5332-11	1	3	0
	D5332-15	1	13	0

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

D5332-17	2	4	0
D5332-7	1	3	0
D5332-9	1	3	0
D5333-1	1	5	0
M304EX0.75-16F	5	837	0

Part Specifications

Specifications could not be found.

Plex 7/12/18 9:16 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐					
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Container No: S102960

Part: D5336 - 043

Job No: 180715

Serial No/Batch: S102960

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 08/16/18

Past
Trib
Interi

